

Date: Wednesday, 12/11/2008 1:39:47 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE KIT FOR D206-642-511
Job Number	: 43372		
Estimate Number	: 12893		
P.O. Number	:	Part Number	: K642 511
This Issue	: 12/11/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: N/A
First Issue	: / /	Project Number	: N/A
Previous Run	: 43155	Drawing Revision	: N/A
	Type : SKIDTUBES	Material	:
Written By	:	Due Date	: 05/12/2008
Checked & Approved By	: <u>JUD 08.11.12</u>	Qty:	2 Um: Each
Comment	: Est Rev.A 07.06.05 new issue EC Est Rev.B 08.02.05, Per ECN1080P LL		

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 DC DOCUMENT CONTROL



for JUD 09/02/19



Comment: DOCUMENT CONTROL

Create White labels per PPP K642-511 CHG003

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D206648013 GHW Modification



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GHW Kit

Batch: B43186

4.0 D2652 Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
16	D2652	Bushing	<u>B44278</u>

5.0 D2712 Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
10	D2712	Set Screw	<u>B43810</u>

9/12/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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6.0	D29321	Saddle LH Out, 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-1

Saddle

B42317

SP

7.0	D29331	Saddle LH In, 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-1

Saddle

B40281

B42978

SP

8.0	D2934	Saddle Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

B44296

SP

9.0	D2935	Saddle Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

44553

9/2/19

SP

10.0	D29381	Saddle LH Out, 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2938-1

Saddle

B37424

SP

11.0	D29391	Saddle LH In, 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-1

Saddle

B40283

9/2/18

SP

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: K642 511

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 D33963 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3396-3 Spacer B3633p

SP

13.0 D3407043 Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3407-043 Tow Ring B43300

20

14.0 D34561 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3456-1 Washer B43002

50

15.0 D34571 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3457-1 Washer B44603

50

16.0 AN3C35A BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 AN3C35A Bolt M109323

50

17.0 AN3C36A BOLT



Comment: Qty.: 9.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch
9 AN3C36A Bolt M109233

⑨
M109771
9/2/19

24

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 43372

Part Number: K642 511

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	AN3C41A	BOLT
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M108084

SC

19.0	AN4C6A	Bolt
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M109147

SC

20.0	AN5C11A	
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M109898

SC

21.0	AN5C12A	
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M107328

SC

22.0	AN5C13A	
------	---------	--



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M107615

SC

23.0	AN5C15A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M105125

9/2/19

SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M107463

SP

25.0

AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M107289

SP

26.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M107551

SP

27.0

AN960C10L

washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M109001

SP

28.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

M110002

9/2/19

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 43372

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C516L

Washer

M109545

SP

30.0

MS210433

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS21043-3

Nut

M110153

SP

31.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

13 MS21043-4

Nut

M110023

9/2/19

SP

32.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 MS21043-5Nut

Nut

M110123

SP

33.0

D36721

Phenolic Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

PHENOLIC WASHER

B42329

SP

34.0

D36723

Phenolic Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

PHENOLIC WASHER

B41775

9/2/18

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 43372

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D36725

Phenolic Washer



B35521



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)
PHENOLIC WASHER

SP

36.0

D36727

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
PHENOLIC WASHER

(24)

B35522

9/21/08

SP

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

209.02.15 (2)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-511 CHG003

Location: _____

See Draft

9/21/08

SP

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/23

Job Completion



11 09.02.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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